Work Order Thursday, January						·	;					Page 1
Item ID: D Revision ID:	03204-3		A	Accept					Setup	Start		
	arm									Stop		
Start Date: 1/ Required Date: 1/ Reference:		Start Qty: 6.00 Req'd Qty: 6.00			Cust Item II Customer:	D:					1 199111181 811	10 HO HON (CON
Approvals:	Process Plan:	RI	Date://-0/-7	Tooling:		ite:		.]	Run	Start		
	QC:		Date:	SPC (Y/N):		ite:				Stop		
Sequence ID/ Work Center ID		Peration Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revisi	on Nbr						- · · · · · · · · · · · · · · · · · · ·				
D3204	Rev A	1									•	
100 	Е	BAND SAW		0.00								-
Bandsaw		Memo		0.00	, ,							
Jeaspa Bandsaw		Cut blank: 2.0	00" x 0.50" x 6.520" long B	ar (+0.030/-0.000)	SL 11/03/22	2		6				
110				0.00								
HAAS 1	ŀ	HAAS CNC VERTICAL Memo	MACHINING #1		me u/03/	/ 3/ ·		_4				
HAAS CNC vertical m	nachine #1	1- Machine a	s per Folio FA344 and Dwg	D3204□2- Deburr□I	dentify as D3204-							
120	Ç	QC2- Inspect parts off ma	achine FAI/FAIB	0.00	m/1/03/	3 <i>1</i>		<u> </u>	Ġ¢.			
QC		Memo		0.00	in the second se			_ ~	-)			<u> </u>
Quality Control	4.	.*			a ng							

Work Order ID 65139

Thursday, January 06, 2011 3:28:45 PM



Page 2

Item ID:

D3204-3

Accept

Setup Start



Revision ID:

Item Name: Arm

Start Date: 1/6/2011

Start Otv: 6.00

Required Date: 1/14/2011

Req'd Qty: 6.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

OC:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Date:

B.A. 11/04/04

Tool # Plan Accept Code Qty

Reject Otv

Reject Number Stamp

Insp.

0.00

0.00

140

Packaging

Packaging

Identify as per dwg & Stock Location;

0.00

0.00

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

While

Picklist Print

Thursday, January 06, 2011 3:28:50 PM

Work Order ID: 65139

Parent Item:

D3204-3

Parent Item Name: Arm



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 6.00

Required Qty: 6.00

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IPP: □C□05.08.11□Added Step 25□ KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.00		Purchased	No		100	f	27.2834	0.5538	3.497684			

6061-T6 Bar .500 x 2.00

Location	1	Loc Qty	Loc Code	
MAT		20		
	114488	20		
MAT02		7.2834		
	110167	7.2834		3.5

DART AEROSPACE LTD	Work Order:	45139
Description: Arm	Part Number:	D3204-3
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

			<u> </u>			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	6.000			Vern 41-	7
5.25	+/-0.030	5,250		a .	1(
0.776	+/-0.010	.775	_		.(
Ø0.760	+0.005/-0.000	Ø.760			N	
0.080	+/-0.010	.080			11	
R0.50	+/-0.010	R.500			11	
2.373	+/-0.010	2371			1.	
0.750	+/-0.010	.750			1/	
R0.380	+/-0.010	R.380			N	
Ø0.375	+0.001/-0.000	8.376			11	
0.300	+/-0.010	-299	·		r)	
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Measured by:	and	Audited by:	A. A	Prototype Approval:	N/A
Date:	11/03/31	Date:	11/04/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A 0	05.02.17	New Issue	KJ/JLM ,	- 1
B 0	06.03.21	Dwg Rev update	KJ/JLM	

W/O:			W	ORK ORDER C	HANGES				•	
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1 100 mg.	
;										
Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ) A:	Date:	<u> </u>
Resolution: Dispo										
NCR:		V	VORK ORD	DER NON-CONF	ORMANC	E (NCR	R)			
DATE	STEP	Description of NC		Corrective Action					Approval	Approval
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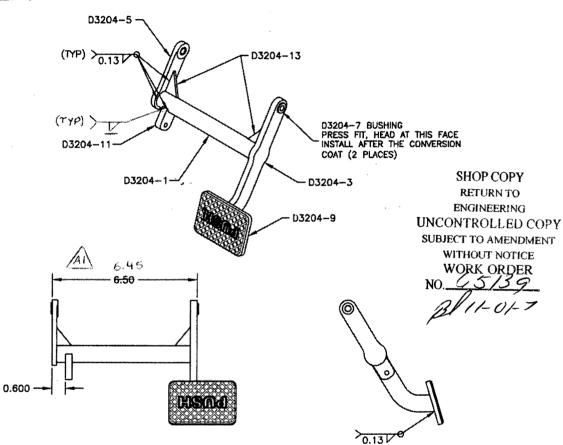
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(2)	CHEC	(ED.)	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
	DATE			TITLE	SCALE
	04.0	1.27		RELEASE PEDAL ASSEMBLY	NTS
	Α		04.01.27	NEW ISSUE	

6.45 WAS 6.50



05.07.15

D3204-041 RELEASE PEDAL ASSEMBLY

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- MATERIAL: AISI 303 SS (M303R)
- MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010 WELD ASSEMBLY PER QSI 004

- 9) POWDER CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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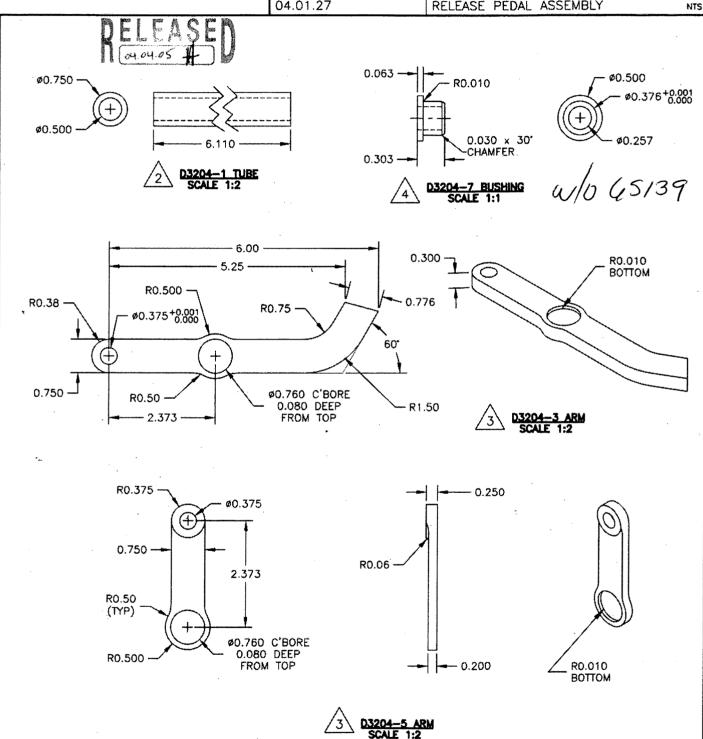
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Part No:	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQA	۸:	Date: _	
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DATE	STEP	Description of NC		Corrective Action	<u> </u>	Ciam			Approval	Approval
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DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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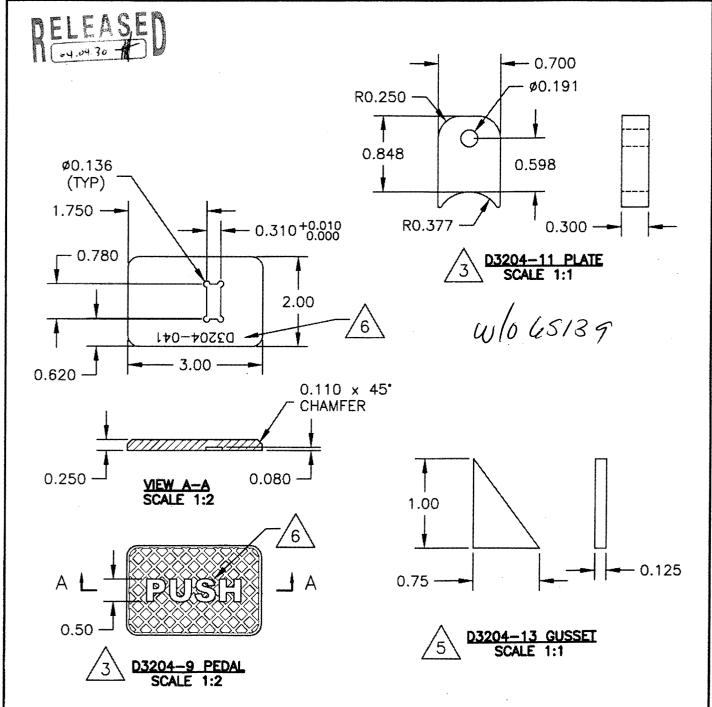
W/O:			VV	ORK ORDER G	MANGES		*		
DATE	STEP	PRC	OCEDURE CH	ANGE		Ву	Date Qty	Date: Date:	Approval QC Inspector
					NCR: Yes No DQA: Date: QA: N/C Closed: Date: NON-CONFORMANCE (NCR) ective Action Section B Verification Approva				
		PAR #: Fault Category: NCR: Yes No DQA: I solution: Disposition: QA: N/C Closed: I WORK ORDER NON-CONFORMANCE (NCR) Description of NC Section A							
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Part No	:	PAR #:	Fault Cat	egory:		NCR: Yes	No DQA:	Date: _	
	F	Resolution:	Dispositi	on:	-	QA: N/C Cid	osed:	Date: _	
NCR:			WORK ORI	DER NON-CONF	ORMAN	CE (NCR)		
DATE	STEP	Description of NC						Date:Date:Date:	
DAIL	SILI	Section A		Action Desc Chief Eng	ription		Section C	Chief Eng	QC Inspector
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#	1	D3204	SHEET 3 OF 3
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04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	C		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Close	ed:	Date:

NCR:			WORK ORI	DER NON-CONI	FORMANC	E (NCR)			
		Description of NC Corrective Ac			Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Desc Chief En		Sign & Date	Section C	Chief Eng	QC Inspecto
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